

Date: Tuesday, 07/04/2009 3:22:24 PM  
 Ser: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG T-HANDLE ASSEMBLY
Job Number	: 47058		
Estimate Number	: 13522		
P.O. Number	:	Part Number	: PB674300151
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 P.13
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/04/2009 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 45026	Material	:
Written By	:	Due Date	: 14/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-04-08</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300187	Tube Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Arm

batch: B41518 = 1xSP 09.04.08

2.0	PB674300191	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Handle

batch: B41519 = 1xSP 09.04.08

3.0	PB674300193	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube End Cap

batch: B41520 = 2xSP 09.04.08

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

SP 09.04.08

(1x)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SP 09.04.09

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: LONG T-HANDLE ASSEMBLY

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Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BF 09/04/09 (IX)

7.0

PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

batch:

B239860-1X

SP 09.04.09.

8.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SPRING SLOTTED PIN

batch:

B111000 = 1X

SP 09.04.09.

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg  
2- install spring pin

SP 09.04.09 (IX)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/04/09

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

2:20pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:50pm

SP 09-04-16 (IX)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 09-04-16 (IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PKg Blade fold.

SS 09/04/17 (x1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 J

Job Completion



mf 09-04-17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

